



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3916-041
Job Sheet 197691



Part No: D3916-041

Job Qty: 10 pcs

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 7/30/19

Description:

Type: SOLD

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Basket - 1	10 pcs		7/30/19	0.00	4.55	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		MAC
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		Jus
							Large Fab - 11 (Various)		
105	QC 5	10 pcs		7/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
107	Large Fab - Basket - 2 - B4B	10 pcs		7/30/19	0.00	5.71	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		

ALL THE TIME CLOCK
IS ON THIS
SEQUENCE,

DAS
24
9-89

MAC

110 QC 5	10 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				120 QC 10	10 pcs
QC 10 - 18	DAS				
QC 10 - 24	24				
QC 10 - 43	9-89				
QC 10 - 50					
QC 10 - 58					
130 Packaging 3-1 - Stock - B4B	10 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	MAC
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	SEP 03 2019
				140 QC 21 - SA	10 pcs
QC 21 - SA - 70	21				
QC 21 - SA - 53	53				

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

105 - (QC5- Inspect part completeness to step on W/O)

107 - (Weid per dwg A/R S.S. rod Batch 1139015 1- weid bushing as per dwg D3916 2- grind welds flush

110 - (QC5- Inspect part completeness to step on W/O)

Plex 7/12/19 3:05 PM Dart.Renwick.Jennife

Plex 7/12/19 3:05 PM Dart.Renwick.Jennifer

7/12/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004-5
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	70 pcs (7 ea)	100-Large Fab - Basket - 1	
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	41,8600 ft (4,166 ea)	100-Large Fab - Basket - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D3759-1	70	89	0
	M304TS0.750W.049	42	543	0

Part Specifications

Specifications could not be found.

Plex 7/12/19 3:05 PM Dart.Renwick.Jennifer



Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 819 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S210886



Part: D3916-041

Job No: 197691

Serial No/Batch: S210886

Revision:

Inspector:

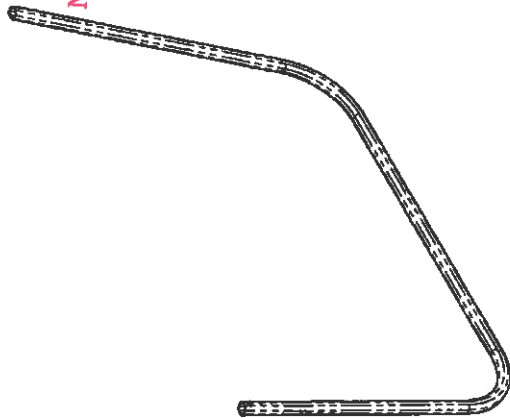
Exp Date:

Instructions: Various STC's

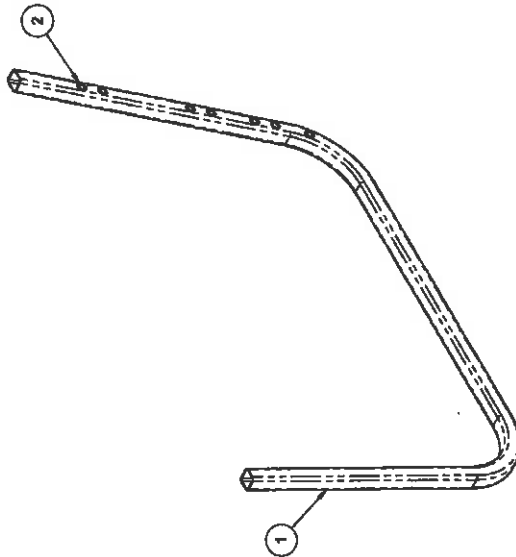
Date: 08/03/19

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3758-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197691



D3916-5 LIGHT RIB



D3916-041 RIB ASSY

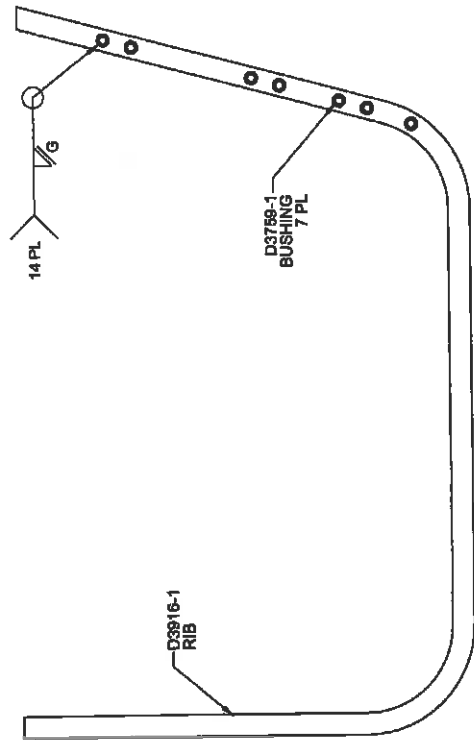
02 10.12.21
UNDER REVIEW
ADDITIONAL HOLE BUSHING
ON D3916-041 RIBS.
RELEASED
2010-03-12
JNP

A	NEW ISSUE	DESCRIPTION	JPH	BY	DATE
REV.					
DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.			
MFG. APPR.		D3916			
APPROVED		TITLE			
DE APPR.		RIB ASSY, 350 BASKET			
DATE	10.03.04	SCALE			
		NTS			

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1 2 3 4 5 6 7 8

D C B A



D3916-041 RIB ASSY

RELEASED
R 2010-03-12
NIP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: .041: 1.84 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	DRAWING NO. D3916
CHECKED		REV. A SHEET 2 OF 4
MFG. APPR.		TITLE RIB ASSY, 350 BASKET
APPROVED		SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.
DATE	10.03.04	